



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-1
Job Sheet 181958



Part No: D3319-1

Job Qty: 6 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev: C Now on Waterjet 06-10-26 JLM IPP REV: D
17.10.25 AS PER DWG REV: D DD VERF: JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		SC 8/28/18
100	Waterjet	6 pcs	8/31/18	8/31/18	0.00	0.63	Waterjet1		SC 8/28/18
110	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Waterjet-2		SC 8/28/18
120	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC8-2		AUG 15 2018
140	Brake NC	6 pcs	8/31/18	8/31/18	0.07	0.43	Brake NC 1		SEP 21 2018
150	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		SEP 21 2018
160	Autoweld 1	6 pcs	8/31/18	8/31/18	0.00	1.54	Automated welding		SEP 21 2018
170	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC10		SEP 21 2018
180	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC5		SEP 21 2018
190	SprayPaint	6 pcs	8/31/18	8/31/18	0.00	0.14	Spray Paint		SEP 21 2018
200	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC3		SEP 21 2018
210	Packaging	6 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		SEP 21 2018
220	QC21-SA	6 Ea	8/31/18	8/31/18	0.00	0.00	QC21		SEP 21 2018

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 2 Form flat on press using DT8776 block

160 - 8259 HARDCOAT B:

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 138946

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	3.7680 sf (.628 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	4	148	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

Description Work Order Deviation 	Disposition 	MRB (QSI042) Approval
	Completed By 	nd / Supervisor
	QA Coordinator 	Approval
	Container No: S102260 Part: D3319-1 Job No: 181958 Serial No/Batch: S102260 Revision: D Inspector: Exp Date: Instructions: Various STC's Date: 08/14/18	

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/l	FAULT CATEGORY
Design ☐	Operator ☐	Bending	
Doc/Data ☐	Offset/Setup ☐	Centre Nc	
Equip/Tooling ☐	Supplier ☐	Cracks	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave	
Material ☐	Use for Testing ☐	Cuffs	
Internal Transport ☐	Poor Information ☐	Crushing	
Tribal Knowledge ☐	Rushing ☐	Heat Treat	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube	
Substation ☐	Process Improvement ☐	Marks/Chatter	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
OTHER :			

1	Wearplate	4.980inches ± 0.030	5.010 4.950	4,986
2	Wearplate	1.600inches ± 0.010	1.610 1.590	1,602
3	Wearplate	2.660inches ± 0.010	2.670 2.650	2,663
4	Wearplate	3.190inches ± 0.010	3.200 3.180	3,194
5	Wearplate	3.563inches ± 0.010	3.573 3.553	3,566
6	Wearplate	4.710inches ± 0.030	4.740 4.680	4,712
7	Wearplate	0.600inches ± 0.030	0.630 0.570	0,606
8	Wearplate	10.576inches ± 0.010	10.586 10.566	10,578
9	Wearplate	11.942inches ± 0.010	11.952 11.932	11,946
10	Wearplate	18.090inches ± 0.030	18.120 18.060	18,094
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,318
12	Wearplate	0.546inches ± 0.010	0.556 0.536	0,549
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	0,318
14	Wearplate	0.670inches ± 0.010	0.680 0.660	0,671
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0,192
16	Wearplate	3.815inches ± 0.010	3.825 3.805	3,816
17	Wearplate	16.100inches ± 0.010	16.110 16.090	16,104

Plex 8/14/18 10:12 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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